

Work Order ID 98585

March-14-13 1:13:52 PM

98585

PRELIMINARY ISSUE

Page 1

Item ID: D4785-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Rib

Start Date: 3/14/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/28/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-03-14 Tooling:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4785	PA2

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4785
2- remove identification marks and deburr



2x

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

13.3.19

2
Inspect as per
Dwg

120

Identify as per dwg & Stock Location: WA

0.00

120

Packaging

Memo

0.00

Packaging

Pl 13.3.18

3x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
---	---	---

<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	
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Work Order ID 98585

March-14-13 1:13:52 PM

98585

Page 2

Item ID: D4785-1
Revision ID: PRELIM
Item Name: Rib

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 3/14/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 3/28/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

WME
13-3-14

POSITIVE RECALL
EFFECTIVE 13-3-14 AUTH h
RELEASED _____ DATE _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

March-14-13 1:13:57 PM

Page 1

Work Order ID: 98585

98585

Parent Item: D4785-1

D4785-1

Parent Item Name: Rib

Start Date: 3/14/13

Required Date: 3/28/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.14 NEW ISSUE VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	497.0403	1.006	2.117895			

M304TS0 500W 049

Square Tubing

**

Pl 13.3.18

Location

WA006

118460

121808

122938

123565

Loc Qty

497.0403313

0.00001534

0.07

257

239.970316

Loc Code

2.12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

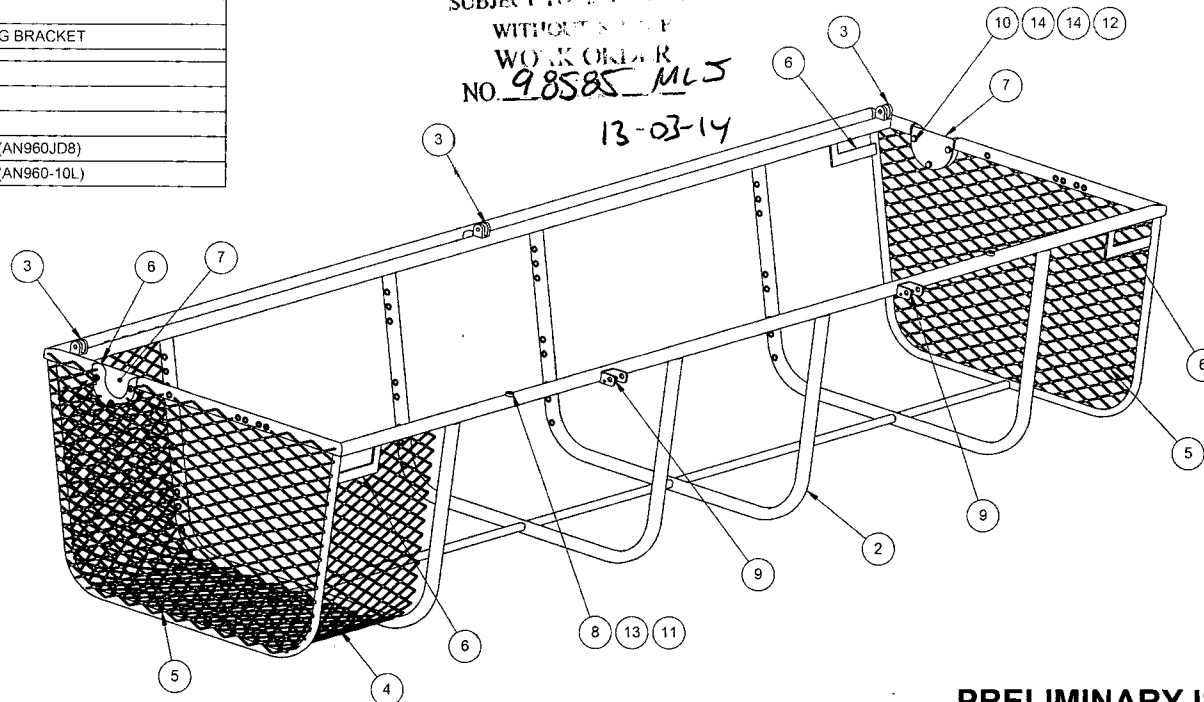
FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
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<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

ITEM NO	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY. LH/RH
2	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
3	3	D4016-1	HINGE HALF, BASE
4	1	D4020-1	MESH BASKET LONG, BASE
5	2	D4020-11	END MESH, BASKET
6	4	D4021-1	HANDLE PLATE
7	2	D4021-5	BLANKING PLATE
8	2	D2931	BUMPER
9	2	D2581	MOUNTING BRACKET
10	6	AN3-10A	BOLT
11	2	MS20600AD4W3	RIVET
12	6	MS21042L3	NUT
13	2	NAS1149DN832J	WASHER (AN960JD8)
14	12	NAS1149F0332P	WASHER (AN960-10L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITHOUT
WORK ORDER
NO. 98585 ML5

13-03-14



PRELIMINARY ISSUE

13.03.02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 46.23 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

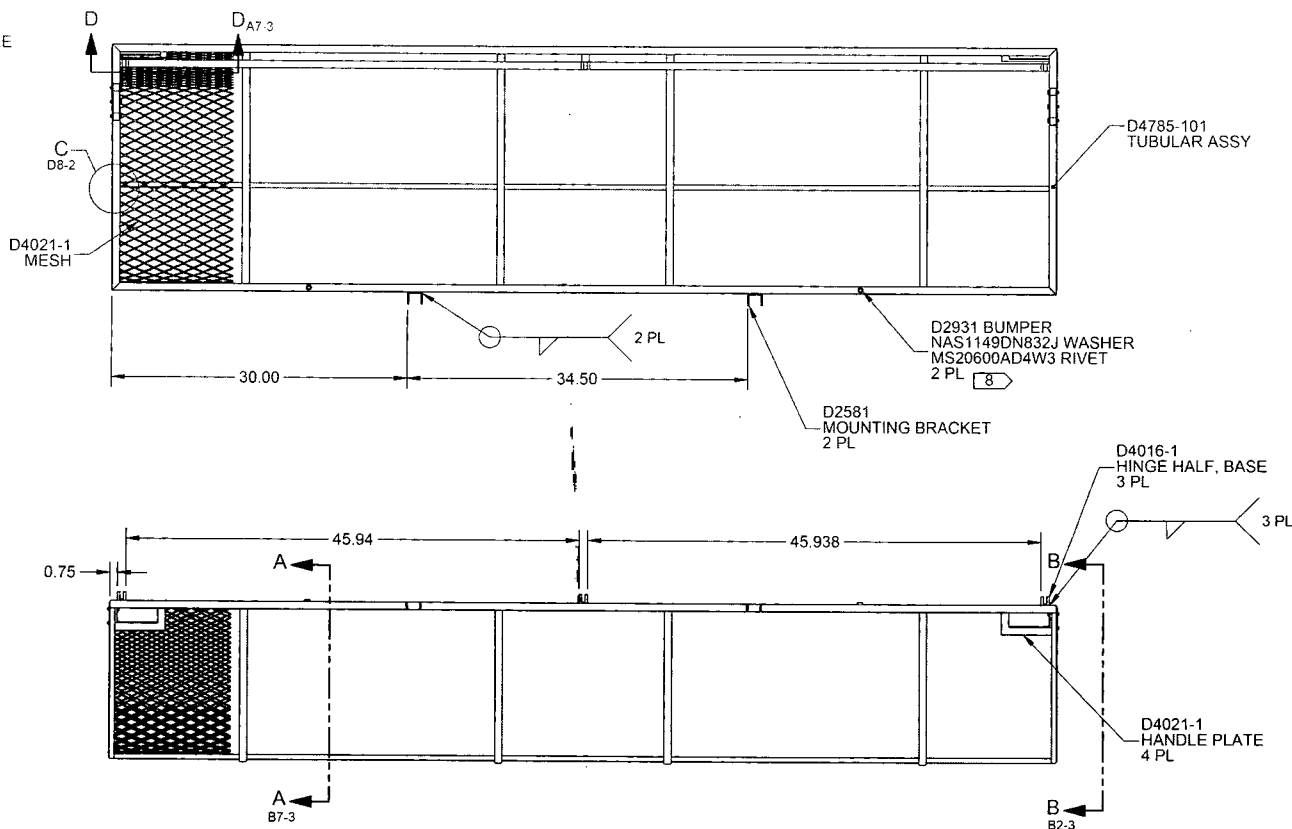
D4785-041 LONG BASKET BASE ASSY, LH/RH

PA2	NEW ISSUE	RF	13.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. PA2
MFG. APPR.		D4785	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.03.02	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

92525

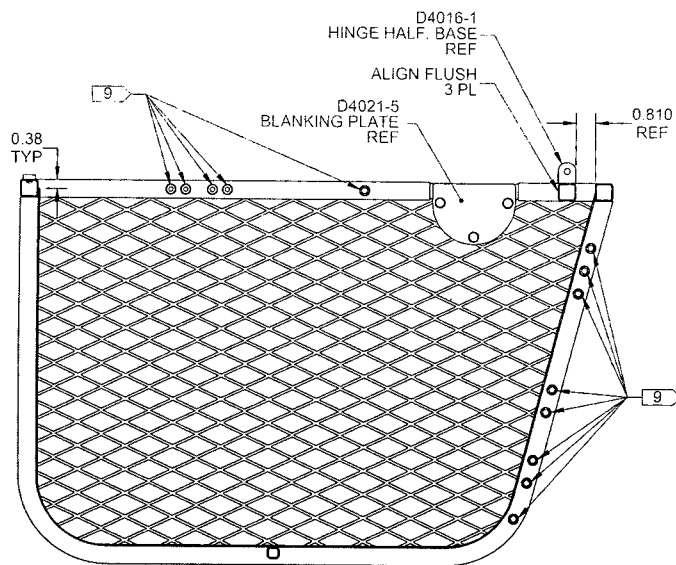
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2

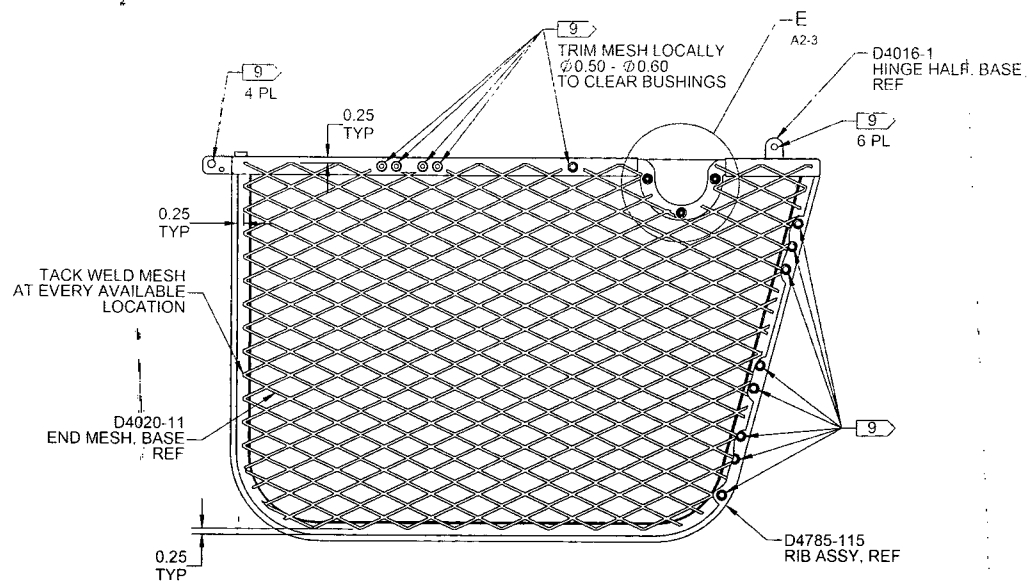


D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

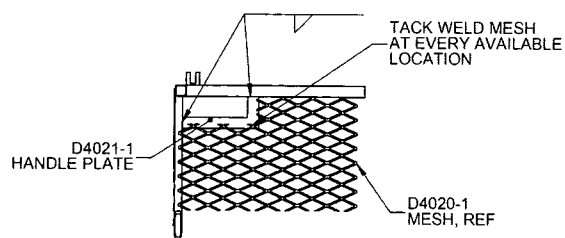
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA2
MFG. APPR.		D4785	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.03.02	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



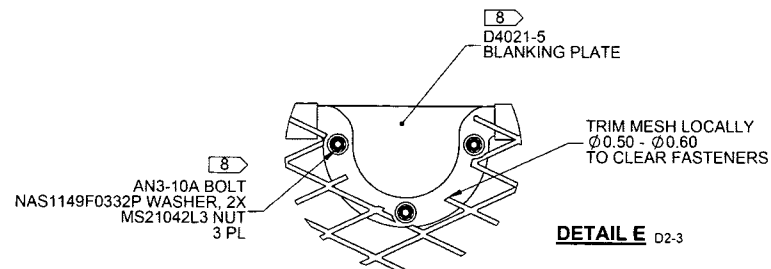
SECTION A-A B7-2



SECTION VIEW B-B A2-2



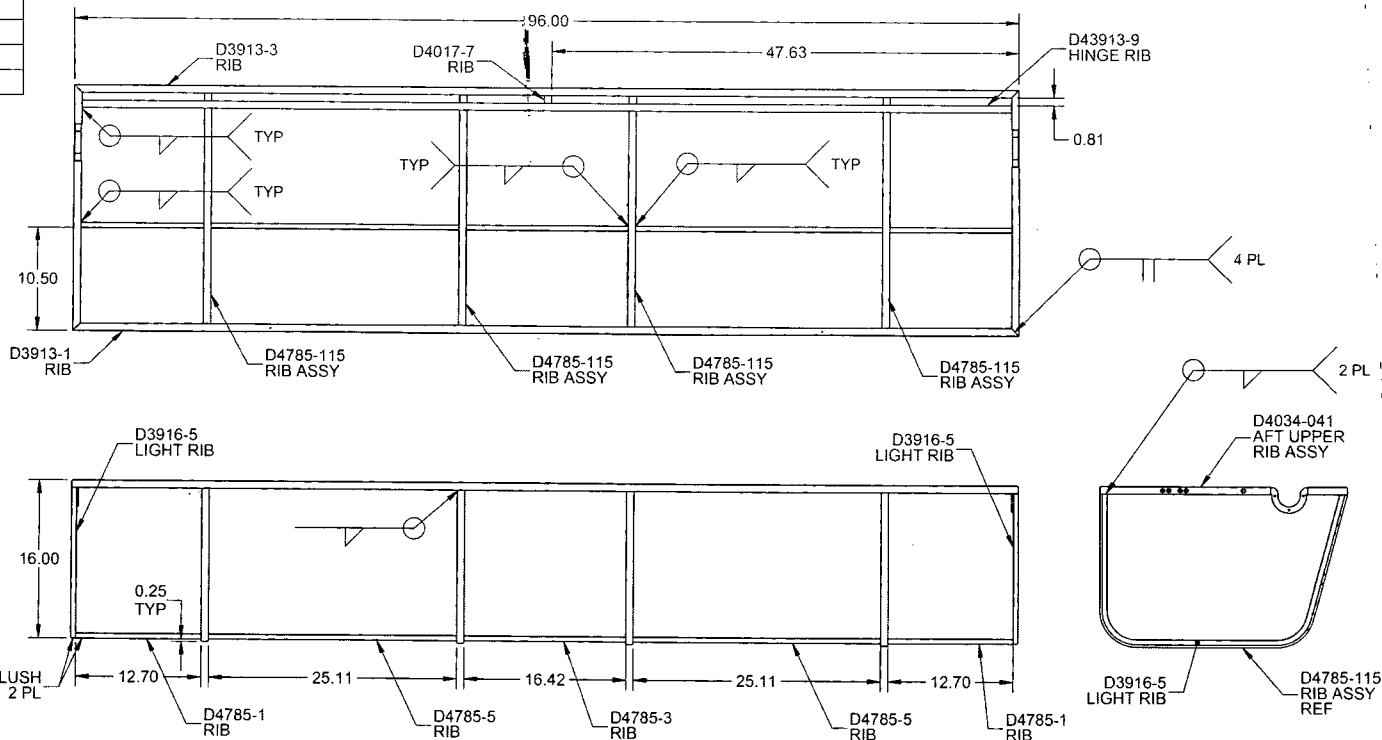
SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. PA
MFG. APPR.		D4785	SHEET 3 OF
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.03.02	COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	QT -10	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	4	D4785-115	RIB ASSEMBLY
4	1	D4785-3	RIB
5	2	D4785-5	RIB
6	1	D4017-7	RIB
7	1	D4034-041	AFT UPPER RIB ASSY
8	1	D4034-043	FWD UPPER RIB ASSY
9	2	D3916-5	RIB, LIGHT
10	1	D3913-1	RIB
11	1	D3913-3	RIB
12	1	D3913-9	HINGE RIB



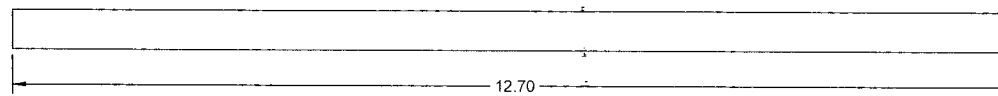
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 25.25 lbs
- 8) WELD PER DART QSI 004

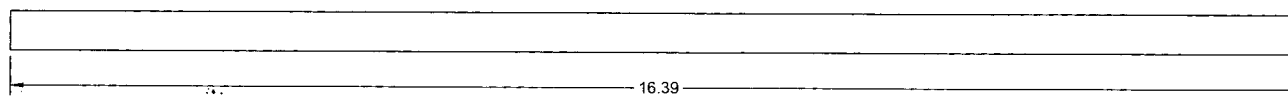
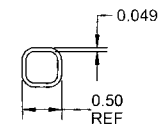
D4785-101 TUBULAR ASSEMBLY, LH/RH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA2
MFG. APPR.		D4785	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.03.02	<small> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

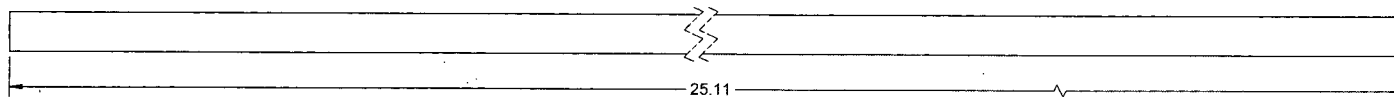
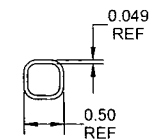
98585



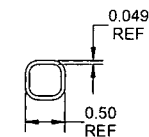
D4785-1 RIB



D4785-3 RIB



D4785-5 RIB



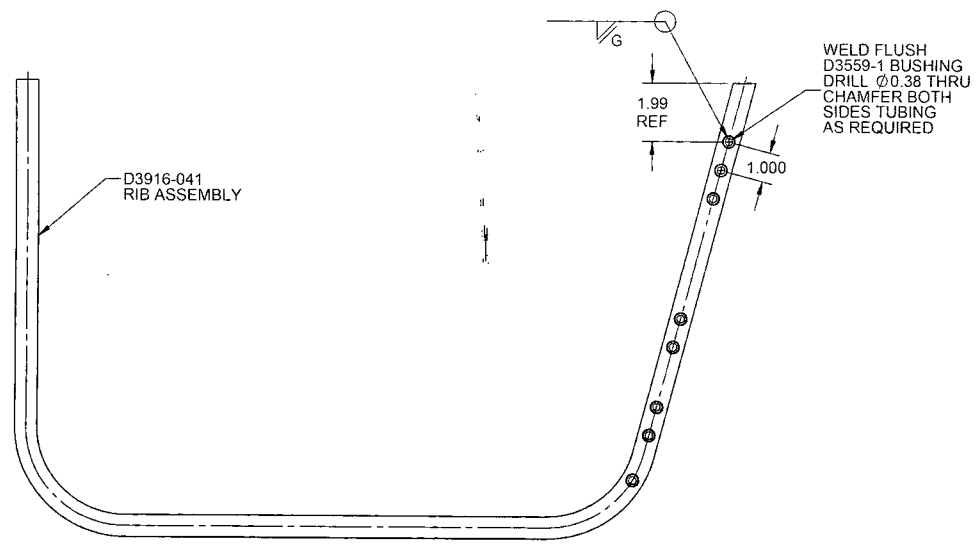
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4785	REV. PA2 SHEET 5 OF 6
MFG. APPR.		TITLE LONG BASKET BASE ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2013 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	13.03.02		

985 J

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D3916-041	RIB ASSY
3	1	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D3916-041 RIB ASSY


- NOTES:
- 1) MATERIAL: D3916-041 RIB ASSEMBLY
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE ASSEMBLED WEIGHTS
 - 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA2
MFG. APPR.		D4785	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.03.02	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE LTD		Work Order:	598585
Description: Rib		Part Number:	04785-1
Inspection Dwg: 04785 Rev: PAO			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:		Audited by:		Preliminary Approval:	
Date:	13.3.19	Date:		Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

Receiving Report

Date: 12/11/05
 Supplier: ESG-66

Batch No: M123565
 Dart P/O: 18070

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: QAS Yes ☒ No ☐ N/A ☐
 Shipment Complete: 14 Yes ☒ No ☐ N/A ☐
 QC6 Inspection: 12/11/05 N/A ☒
 Work Order: N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 12/11/05
 Date [Signature]
 Received/Costing
 Initial

Location

Purchase Order Receipt Listing

Page 1 of 1

Monday, November 05, 2012 7:11:15 AM

All amounts are calculated in domestic currency.

All Vendors PO ID po18010 Receipt Dates from 11/5/2012 to 11/5/2012 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
------------------------------------	-----------------------------	------------	--	----------------------	-------------------------------	---------------------------	-------------------------	------------------------------	--	-------------------------------	----------

VendorID\Vendor Name	VU-EAG001 Eagle Stainless										
PO18010	1		M304TS0.500W.049 f		11/9/2012	11/5/2012	585.0000	\$6.25	0.0000	0	\$3,656.25
USD	No		Square Tubing f		600.0000	DESJ02		\$3,656.25	0.0000	0	
			123565								

Total Received Quantity:	585.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$3,656.25
Total Balance Due Quantity:	0.0000



EAGLE STAINLESS

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650, 508-528-8650 Fax: 800-520-1954, 508-520-1954 Email: eagle@eagletube.com Web: www.eagletube.com

Packing List

Bill Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

PO Number: PO18010

Shipment No: 94528
Shipment Date: 10/30/12
Order Number: 111505
Order Date: 09/27/12

Customer Code: 000000001912
Phone: (613) 632-5200

Terms: Net 30 Days

Ship Via: **FED X COLL 151793240**

Quantity				Unit	Description	Job Number
Open	Shipped	Back Ord	Canceled			
600	585	✓ 0		15 FT	1912-SQ0500049T304 T304 Smis Square Tubing .500" x .500" x .049" Wall x (60 - 117" + .500"/-000 Lengths.) As Drawn Temper. Chem to ASTM A269. Certs Required. Pack to Protect.	111505-01

12/1/12

This is NOT an Aerospace Application.....

COPIES WITH SHIPMENT
COPIES WITH SHIPMENT
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EAGLE STAINLESS

Tube and Fabrication, Inc

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: eagletube@eagletube.com

MATERIAL TEST REPORT CERTIFICATE OF CONFORMANCE

SOLD TO: Dart Aerospace, Ltd.

DATE: 10/29/2012

ADDRESS: 1270 Aberdeen Street

PURCHASE ORDER: PO18010

Hawkesbury ON K6A 1K7

OUR ORDER#: 111505

PART #: NA

REVISION: NA

HEAT #: YT4421

SOURCE: 60-45541-10-12

ITEM: .500 OD X .500 OD X .049 WALL T304/304L SMLS

Spec: ASTM A269-08/A213-09B ASME SA213-07

Temper: ANNEALED

Quantity: 585 Units: FT

C: .028 Ti: -
Si: .480 Cb: -
Mn: .760 Ta: -
P: .039 Fe: balance
S: .004 Cu: -
Ni: 8.90 Al: -
Cr: 18.13 N: -
Mo: - Co: -

Misc Chem: -

Misc Chem: -

Misc Chem: -

Notes: -

Notes: -

Notes: -

Comments:

Passivation Per ASTM A967: -

Yield (PSI): 44,200

Tensile (PSI): 98,600

Elong. (% IN 2"): 63

Hardness (Rockwell): B 74

Flattening: PASS

Flaring: PASS

Rev F/B: -

Flange: -

Int C/E: -

Eddy Current: PASS

Hydrostatic: PASS

Grain Size: -

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2011/65/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS). Reports governing this material are on file.

Bernie Pearson

EAGLE STAINLESS TUBE AND FABRICATION INC.
Bernie Pearson
Quality Assurance Manager

BP

Int.

10/29/2012

Date

DAS
14
12/1/05



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18010

Purchase Order Date 9/26/12

PO Print Date 9/26/12

Page Number 1 of 1

Order From :

VU-EAG001

EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Contact Name

Vendor Phone

800 528 8650

Vendor Fax

800 520 1954

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
123565

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TS0.500W.049	Square Tubing	11/09/12 Yes	600.00 f	Fedex Freight C	\$6.2500	\$3,750.00

Special Inst:

MATERIAL: AISI 304/316 SEAMLESS
STAINLESS STEEL SQUARE TUBING
ASTM A554 MILL FINISH OR ASTM
A269 MILL FINISH

PO Total:

\$3,750.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 9/26/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required: YES NO